

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007266**Date Inspected:** 03-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huan Wen Pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #032 located on FB003 – 159. Welder is identified as 203781. ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2233 – Tc – u4b - f.

FCAW process welding of weld joint #004 located on LD001 - 036. Welder is identified as 215676. ZPMC QC is identified as Xiang Fang Fang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #044 located on FB003 – 175. Welder is identified as 062708. ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2233 – Tc – u4b - f.

BAY 3

This QA Inspector observed the following work in progress:

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FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD002 – 027. Welder is identified as 204338. ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 - F.

FCAW process welding of weld joint #099 located on Floor Beam FB011 – 195. Welder is identified as 044790. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 - 3.

SMAW process welding of weld joint #017 located on Floor Beam FB011 – 035. Welder is identified as 200583. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

BAY 5

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

20TR1 – 016 – 005 ~ 008 – Green Tag # 008546
20TR1 – 015 – 005 ~ 008 – Green Tag # 008547
20TR1 – 014 – 005 ~ 008 – Green Tag # 008548
20TR1 – 013 – 005 ~ 008 – Green Tag # 008549
20TR1 – 012 – 005 ~ 008 – Green Tag # 008550
20TR1 – 011 – 005 ~ 008 – Green Tag # 008551
20TR1 – 010 – 005 ~ 008 – Green Tag # 008552
20TR1 – 009 – 005 ~ 008 – Green Tag # 008553
20TR2 – 016 – 005 ~ 008 – Green Tag # 008542
20TR2 – 015 – 005 ~ 008 – Green Tag # 008543
20TR2 – 014 – 005 ~ 008 – Green Tag # 008544
20TR2 – 013 – 005 ~ 008 – Green Tag # 008545

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #033 located on Floor Beam FB204 – 030. Welder is identified as 217562. ZPMC QC is identified as Chen Shi Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 - 3.

FCAW process welding of weld joint #033 located on Floor Beam FB205 – 011. Welder is identified as 215185. ZPMC QC is identified as Chen Shi Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

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No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep
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Quality Assurance Inspector

Reviewed By:	Prue,Erik
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QA Reviewer
